

Date: Thursday, 7/20/2006 1:05:52 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 27995	Part Number	: D2574
Estimate Number	: 10534	Drawing Number	: D2574 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 7/20/2006 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: 7/20/2006 Type : MACHINED PARTS	Due Date	: 8/5/2006
Previous Run	: 27890	Qty:	16 Um: Each
Written By	: <u>HA</u>		
Checked & Approved By	: <u>HA 06.07.21</u>		
Comment	: Est Rev: 1 As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B25350

5.6 06/09/01

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 27995 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

9ml/5.6 06/09/06

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

9ml 06/09/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9ml/5.6 06/09/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/20

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 7/20/2006 1:05:52 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27995

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/09/22 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06-09-24 16

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-09-25

(16)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PU 9/9/26 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51478

06/09/26 (16)  
06/09/26 (16)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/26

(16)

Job Completion



06-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27995
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.176	1.750	1.748		
C	3.495	3.505		3.501	3.496	3.498	3.500		
D	1.745	1.755		1.747	1.176	1.750	1.748		
E	7.990	8.010		8.004	8.005	8.003	8.004		
F	0.490	0.510		0.500	0.501	0.502	0.502		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.498	0.495	0.495	0.498		
J	1.174	1.184		1.177	1.176	1.176	1.180		
K	0.558	0.578		0.569	0.561	0.566	0.570		
L	1.174	1.184		1.177	1.176	1.176	1.180		
M	1.365	1.375		1.369	1.367	1.371	1.370		
N	2.495	2.505		2.497	2.497	2.497	2.497		
O	4.119	4.129		4.119	4.124	4.119	4.123		
P	0.115	0.135		0.119	0.123	0.125	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.241	0.241	0.244	0.242		
S	0.115	0.135		0.127	0.121	0.116	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.230	0.230	0.231		
W	0.115	0.135		0.126	0.125	0.127	0.123		
X	0.307	0.312		0.308	0.309	0.308	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.369	0.363	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.623	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.240	0.241	0.240	0.242		
AE	1.500	1.520		1.507	1.511	1.513	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.240	0.240	0.242		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.043	0.035	0.035	0.035		
Accept/Reject									

Measured by: J. G. I.	Audited by: MS
Date: 06/09/06	Date: 06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27995
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

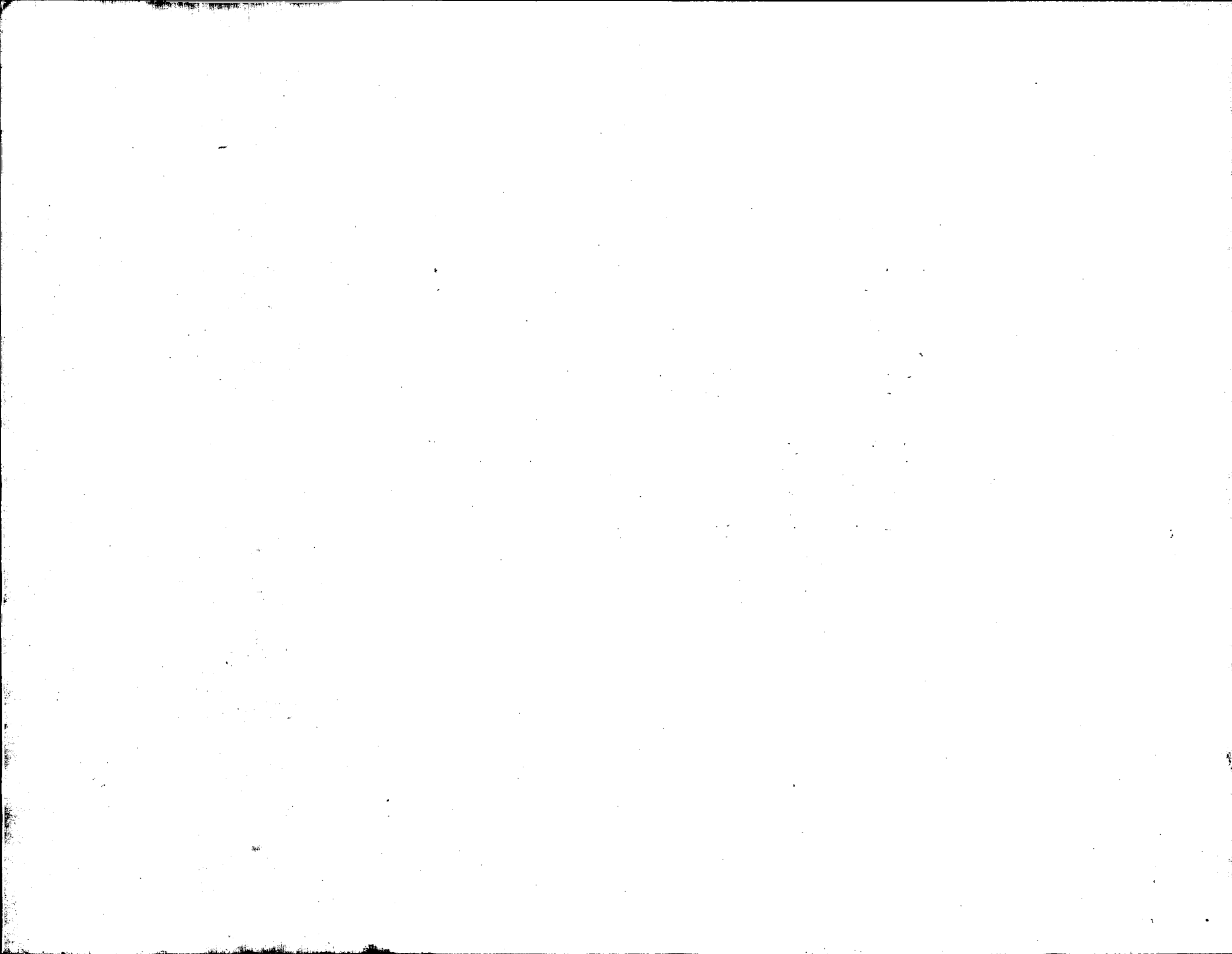
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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4g		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.746	1.748	1.746	1.746		
C	3.495	3.505		3.500	3.497	3.495	3.499		
D	1.745	1.755		1.746	1.748	1.746	1.746		
E	7.990	8.010		8.004	8.004	8.005	8.004		
F	0.490	0.510		0.498	0.495	0.500	0.496		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.502	0.499	0.498	0.495		
J	1.174	1.184		1.175	1.178	1.178	1.175		
K	0.558	0.578		0.565	0.568	0.565	0.566		
L	1.174	1.184		1.175	1.178	1.178	1.179		
M	1.365	1.375		1.368	1.366	1.370	1.367		
N	2.495	2.505		2.496	2.496	2.499	2.497		
O	4.119	4.129		4.123	4.122	4.121	4.121		
P	0.115	0.135		0.123	0.122	0.122	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.253	0.250		
S	0.115	0.135		0.123	0.122	0.120	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.189		
U	3.210	3.250		3.230	3.230	3.231	3.231		
V	0.230	0.250		0.230	0.230	0.236	0.235		
W	0.115	0.135		0.125	0.125	0.125	0.127		
X	0.307	0.312		0.309	0.309	0.310	0.309		
Y	0.760	0.765		0.761	0.760	0.761	0.760		
Z	0.352	0.372		0.361	0.363	0.364	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.245	0.246		
AE	1.500	1.520		1.510	1.511	1.511	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.247	0.247	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		
Accept/Reject									

Measured by: Ed Pmk	Audited by: MS
Date: 06/09/19	Date: 06/09/22

Measured by: Ed Pmk	Audited by: MS
Date: 06/09/19	Date: 06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>27995</b>
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B	1.745	1.755		1.747	1.746	1.746	1.746		
C	3.495	3.505		3.499	3.498	3.499	3.500		
D	1.745	1.755		1.747	1.746	1.746	1.746		
E	7.990	8.010		8.005	8.005	8.006	8.005		
F	0.490	0.510		0.500	0.497	0.500	0.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.502	0.502	0.497	0.499		
J	1.174	1.184		1.177	1.175	1.175	1.179		
K	0.558	0.578		0.568	0.564	0.566	0.565		
L	1.174	1.184		1.177	1.175	1.175	1.179		
M	1.365	1.375		1.367	1.366	1.368	1.371		
N	2.495	2.505		2.496	2.498	2.498	2.497		
O	4.119	4.129		4.121	4.120	4.122	4.122		
P	0.115	0.135		0.122	0.121	0.123	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.253	0.251		
S	0.115	0.135		0.118	0.121	0.121	0.119		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.280		
V	0.230	0.250		0.236	0.237	0.236	0.236		
W	0.115	0.135		0.120	0.123	0.122	0.122		
X	0.307	0.312		0.309	0.308	0.309	0.308		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.363	0.362	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.626	0.626	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.243	0.245	0.244		
AE	1.500	1.520		1.509	1.511	1.511	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.251	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.035	0.035	0.038	0.035		
Accept/Reject									

Measured by:	EP
Date:	06/09/17

Audited by:	MS
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



5

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>27995</b>
<b>Description: Saddle, Aft Inboard</b>	<b>Part Number:</b>	<b>D2574</b>
<b>Inspection Dwg: D2574 Rev. E</b>		<b>Page 1 of 1</b>

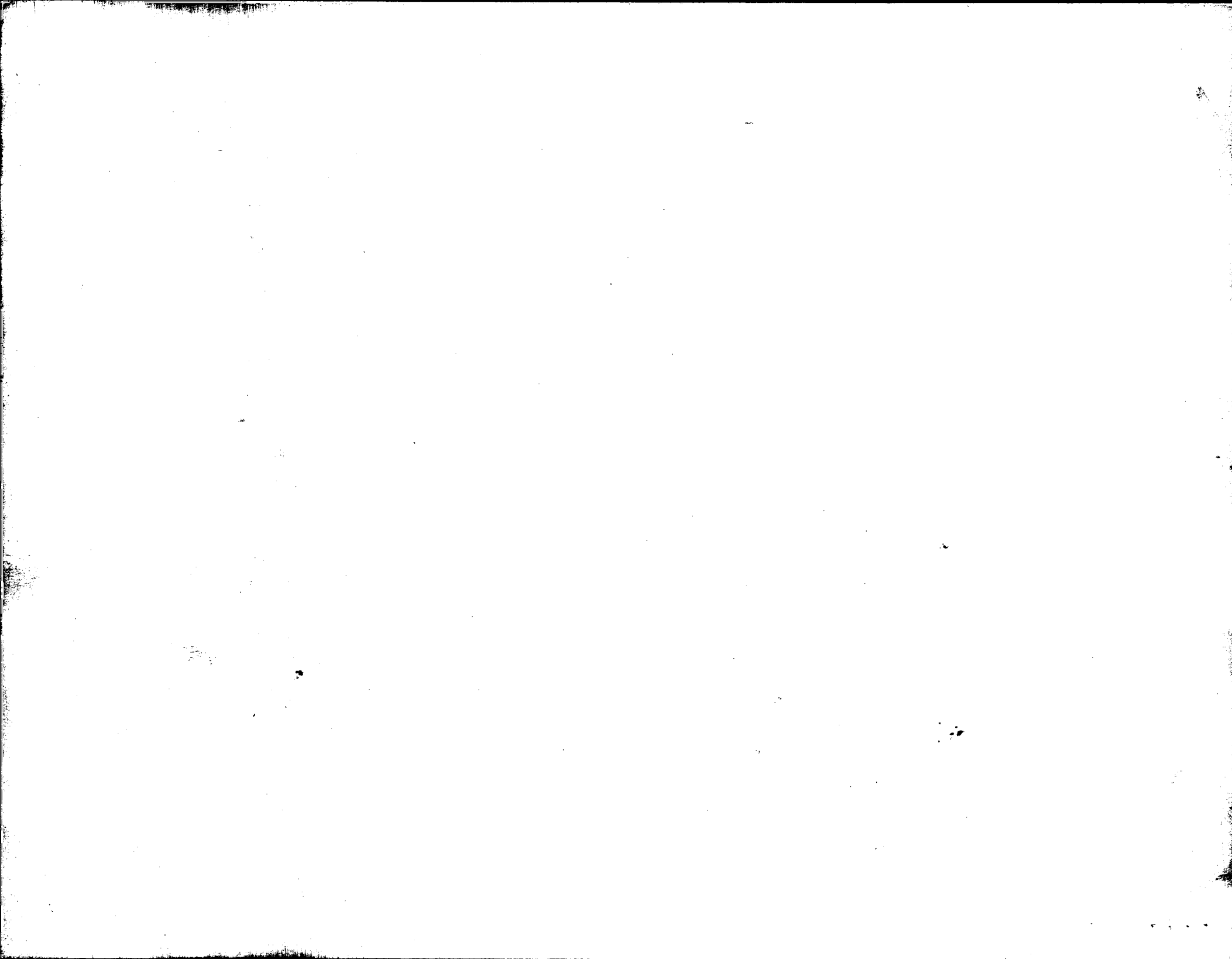
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

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				1	2	3	4 <sub>16</sub>		
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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.004	8.006	8.005		
F	0.490	0.510		0.502	0.502	0.505	0.503		
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.500	0.500	0.502	0.500		
J	1.174	1.184		1.178	1.178	1.179	1.179		
K	0.558	0.578		0.567	0.567	0.568	0.568		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
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Q	0.115	0.135		0.135	0.135	0.135	0.135		
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W	0.115	0.135		0.128	0.124	0.121	0.124		
X	0.307	0.312		0.309	0.309	0.309	0.308		
Y	0.760	0.765		0.766	0.760	0.766	0.760		
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AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.631	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.249	0.255	0.247		
AE	1.500	1.520		1.510	1.510	1.508	1.508		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.255	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.036	0.036	0.035	0.035		
Accept/Reject									

Measured by:	<i>ML</i>
Date:	06/09/17

Audited by:	MS
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>



RELEASED

05.12.06

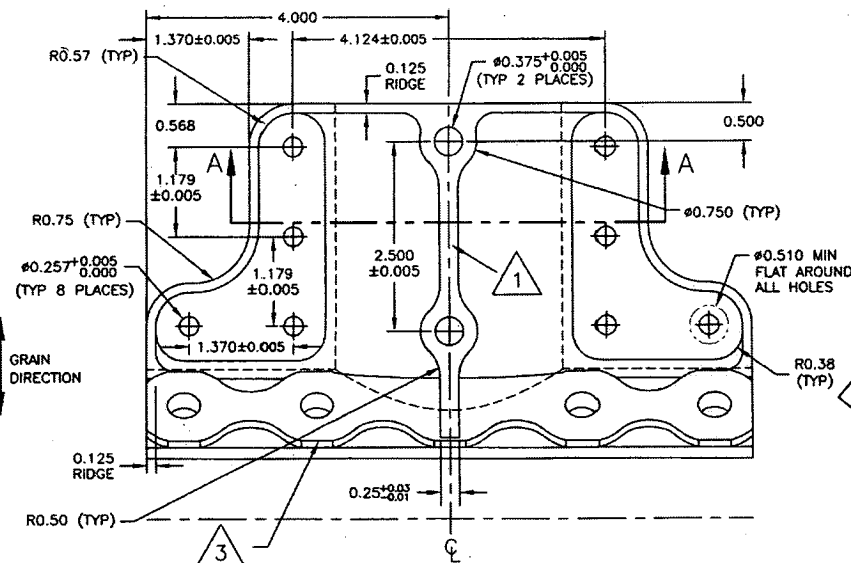
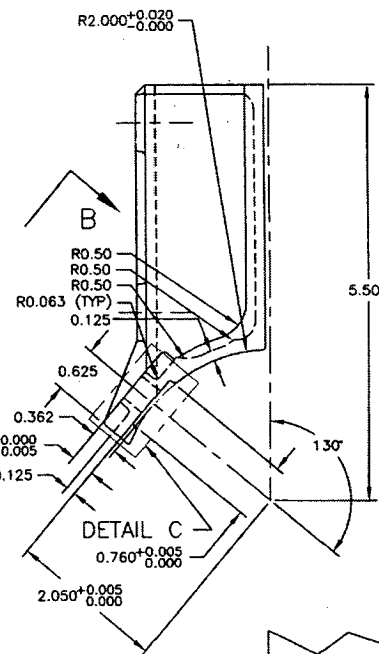
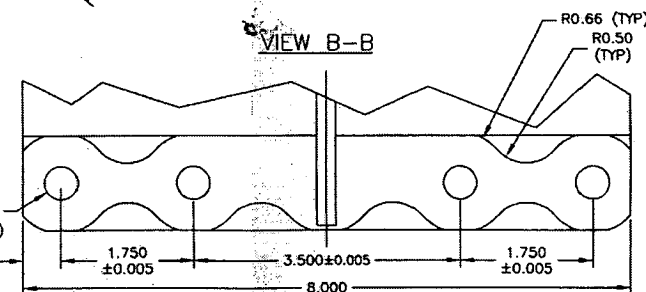
# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

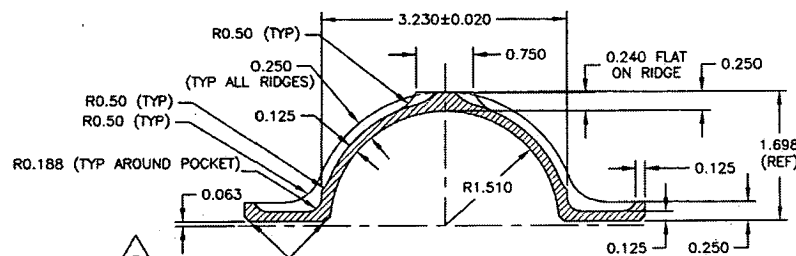
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

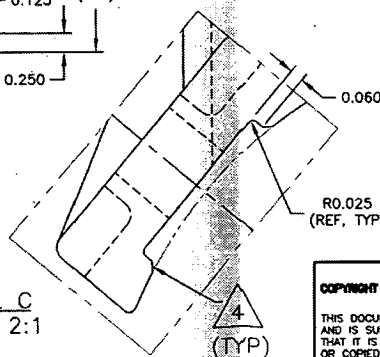
## VIEW B-B



## SECTION A-A



## DETAIL C SCALE 2:1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE
		SCALE 2:3

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27995